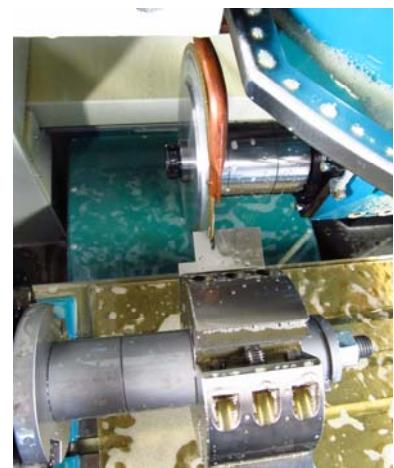


## HSS Profile Milling Cutter Ø194 Z2

A16-210

The grinding of deep pocketlike profiles in HSS Profiled Cutters requires a switch of the WGPA of the wheel to be able to achieve enough side clearance and when the profiled knives are very long. On a CFG configuration, roughing is done from behind, where the profilepregrinding and finishing is done above or at the point chosen with WGPA.



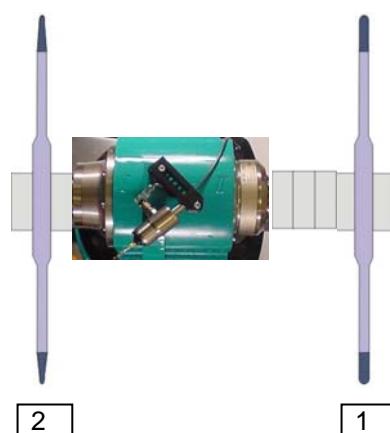
### 1. Cycletime for Production

Workpiece: Ø 194 mm, Z 2, Length 60 mm, clearance angle 20°, rake angle 13° Material HSS					
Operations	Probe	Prf Rough	Prf Pgnd	Prf fin 1	Prf fin 2
Feed [mm/Min]	2000	45	65	95	130
Power [kW]		2	1	1	1
Cutting feed [m/s]		32	32	32	32
Used wheels		1	1	2	2
Grinding time [s]	6	1600	183	128	96
Total cycle time	33 Min 33				

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	14F1 Ø200 R1.5
2	14F1 Ø200 R1.0



### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 310i

Software: Quinto 5

Accessories:

Responsable engineer: OP. 2.5.11

[www.schneeberger.ch](http://www.schneeberger.ch)

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